



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-541-047
Job Sheet 174186



Part No: D205-541-047

Job Qty: 1 ea

Part Name: Heli-Access-Step™ - LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV G SHEET 18 IPP Rev:A new issue 08-02-19 verified by: LL IPP Rev:B Ecn 1157 08-03-19 DD verified by: IPP Rev:C bolt was AN3 now AN4 DD 10.03.18 verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea	4/18/18	4/18/18	0.00	0.00	Start Up Stores/Pkg-1		APR 19 2018
110	Packaging	1 pcs	4/18/18	4/18/18	0.00	0.00	Packaging1-2		APR 25 2018
120	QC	1 pcs	4/18/18	4/18/18	0.00	0.00	QC4		58
125	DC	1 pcs	4/18/18	4/18/18	0.00	0.00	DC		9-89 DAS
130	Packaging	1 pcs	4/18/18	4/18/18	0.00	0.00	Packaging3-1		APR 25 2018
140	QC21-FG	1 Ea	4/18/18	4/18/18	0.00	0.00	QC21		58 9-89

Part Op 125 - Photocopy bluefile & type labels per PPPD205-541-047 CHG001

Descriptions: 130 - Identify and pack for shipping as per PPP D205-541-047 Location: _____ PPP Rev: _____ APR 2 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-13A	Bolt	6 Ea (6 ea)	90-Start up Operation	5045860
AN4-14A	Bolt	6 Ea (6 ea)	90-Start up Operation	5027723
D3724-041	Step Assembly	1 Ea (1 ea)	90-Start up Operation	
D3731-1	Plate	1 Ea (1 ea)	90-Start up Operation	5010211
D3751-1	Shim	2 Ea (2 ea)	90-Start up Operation	5058997
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5045901
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	5045845

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-13A	6	735	0
	AN4-14A	6	409	0
	D3724-041	1	0	0
	D3731-1	1	13	0
	D3751-1	2	0	0
	MS21042L4	12	3,439	0
	NAS1149D0463J	24	4,500	0

5051535x



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartero.com
www.darteerospace.com

Container No: S062760



Part: D205-541-047

Job No: 174186

Serial No/Batch: S062760

Revision:

Inspector:

Date: 04/19/18

Part Specifications

Specifications could not be found.

Plex 3/12/18 3:33 PM Dart.Gagnon.Michelle

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

Change Record

PAGE 1 OF 1

Part Number: D205-541-047/-048

Description: HELI-ACCESS STEP LH/RH

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					